

Gray

Date: Tuesday, 14/04/2009 11:04:18 AM
User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GUIDE
Job Number :	47141		
Estimate Number :	12687		
P.O. Number :		Part Number :	D35711
This Issue :	14/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3571 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	46282	Drawing Revision :	A
	Type :	Material :	
	MACHINED PARTS	Due Date :	21/04/2009
Written By :		Qty:	20
Checked & Approved By :	<i>MF 09-04-14</i>	Um:	Each
Comment :	Est Rev:A New Issue 07-02-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X01500	6061-T6 Bar .750 X 1.50
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Comment: Qty.: 0.2531 f(s)/Unit Total: 5.0610 f(s)

6061-T6 Bar .75" X 1.5"

Batch: *M110167*

JL 09/04/24

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 2.90 " long

JL 09/04/24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA675Rev: *A* & Dwg D3571 Rev: *A*

2-Deburr per dwg D3571

MF 09/04/27 JL 09/04/28

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MF 09/04/27 JL 09/04/28

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SP 09/04/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/04/2009 11:04:19 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 47141

Part Number: D35711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

fl

09-04-29

(x20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

13:25

OVEN TEMPERATURE:

320°

FINISH TIME:

13:55

cmd/Fl.

(120)

09/04/30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-01

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

244

9/5/1

(224)

Sp

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04

Job Completion



mr
09-05-01

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4741
Description: Guide		Part Number: D3571-1
Inspection Dwg: D3571	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.699	✓			
Ø1.00 Depth 100	+/-0.010	Ø.999 / 1.00	✓			
2.75	+/-0.030	2.75	✓			
1.38	+/-0.030	1.37	✓			
1.25	+/-0.030	1.24	✓			
0.63	+/-0.010	.632	✓			
0.031 chamfer	+/-0.010	.031	✓			
Ø0.500	+0.006/-0.001	Ø.502	✓			
Ø0.201	+0.005/-0.001	Ø.203	✓			
R0.25	+/-0.030	R.25	✓			
0.260	+0.000/-0.010	.260	✓			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	Ø.385 x 100°	✓			
0.125	+/-0.010	.125	✓			
2.250	+/-0.010	2.242	✓			
0.250	+/-0.010	.254	✓			
0.188	+/-0.010	.187	✓			
0.063 chamfer	+/-0.010	.067	✓			

Measured by: MF	Audited by: SS	Prototype Approval:	N/A
Date: 09/04/27	Date: 09/04/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	SS

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

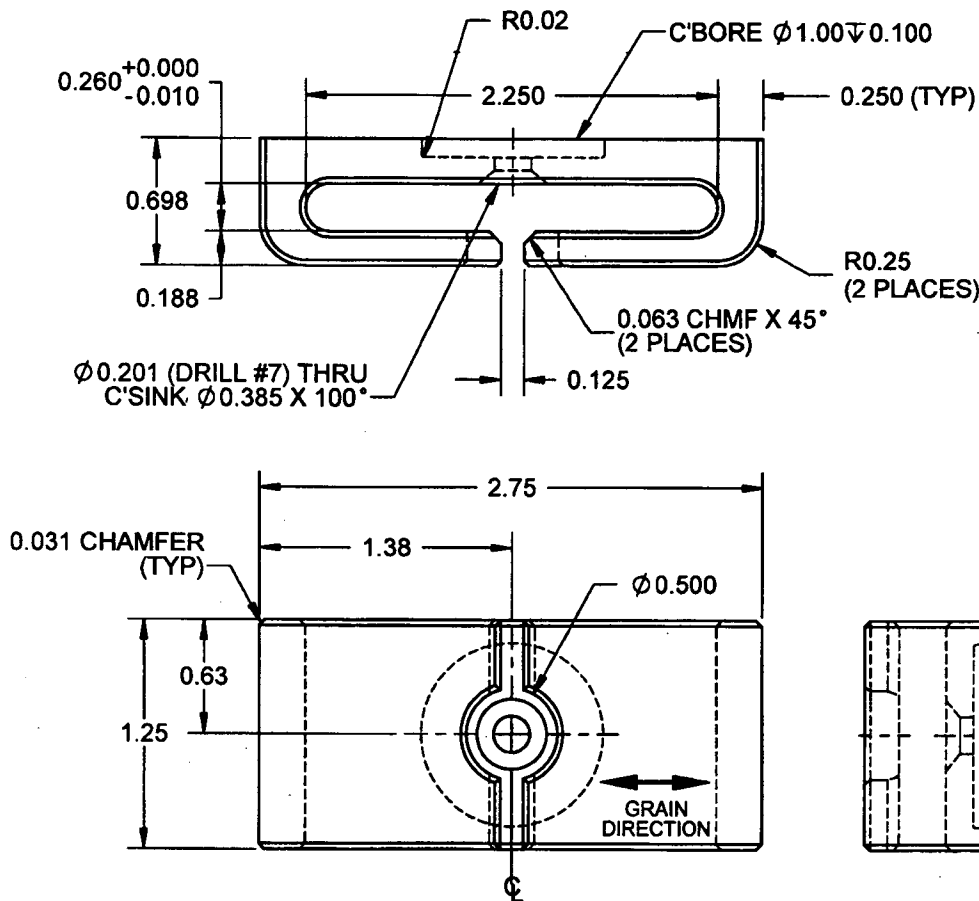
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29	TITLE GUIDE	SCALE 1:1	
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07-04-12 *[Signature]***D3571-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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